

Work Order ID 70742

Tuesday, June 14, 2011 10:02:58 AM



Page 1

Item ID: D4278-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Rib Assembly-Hoop

Start Date: 6/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

mm

Date:

11-06-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4278

C

100

Weld per dwg A/R S.S. rod Batch: *M115278* 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT

2- Weld bushing in rib and grind weld flush as per dwg

M11.06.14 ①

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

QC11.06.15

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/15

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID:	D4278-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Upper Rib Assembly-Hoop					
Start Date:	6/14/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/17/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11.06.15

u/e/15

11-06-15

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 14, 2011 10:02:55 AM

Page 1

Work Order ID: 70742

Parent Item: D4278-041

Parent Item Name: Upper Rib Assembly-Hoop



Start Date: 6/14/2011





Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD ver:EC
11.01.20 AS PER DWG REV.C DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-7 		Manufactured	No			100	Each	2.0000	1	1		11.06.14	
Hoop													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				56996		0							
				69637		2							
D4021-9 		Manufactured	No			100	Each	124.0000	4	4		11.06.14	
Bushing													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		122							
				68063		58							
				70333		64							
				WA005		2							
				66437		2							
D4034-1 		Manufactured	No			100	Each	4.0000	1	1		11.06.14	
Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		4							
				67271		4							
D4034-3 		Manufactured	No			100	Each	0.0000	1	1		11.06.14	
Rib													

B70754

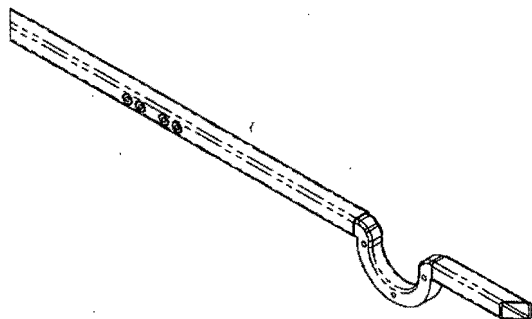
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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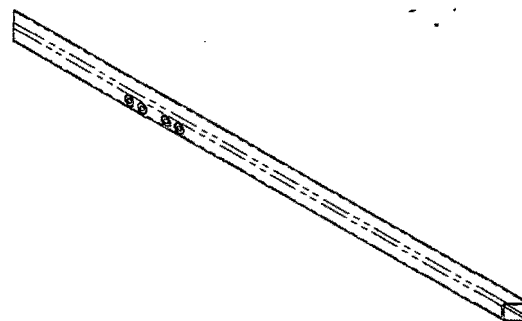
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



RELEASED
2011-01-18
MM

C	ADDITIONAL HOLES ADDED IN D4278-041-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D4278	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
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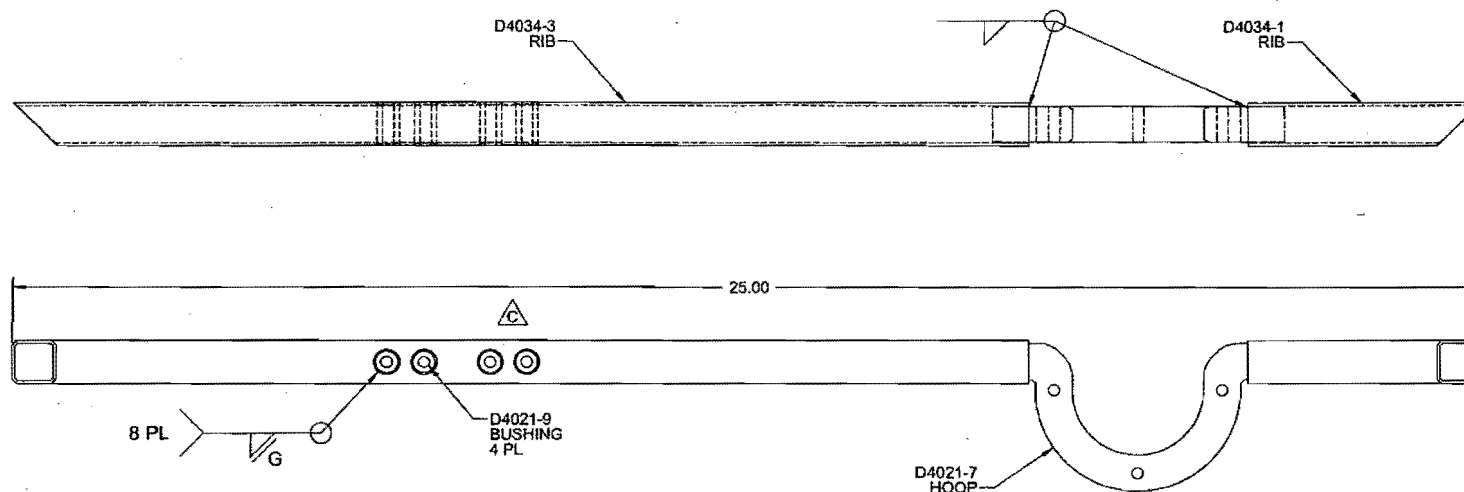
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

RELEASED
2011-01-18

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 2 OF 4
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Dart Aerospace Ltd

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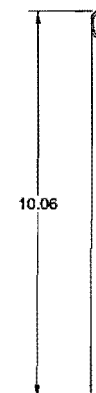
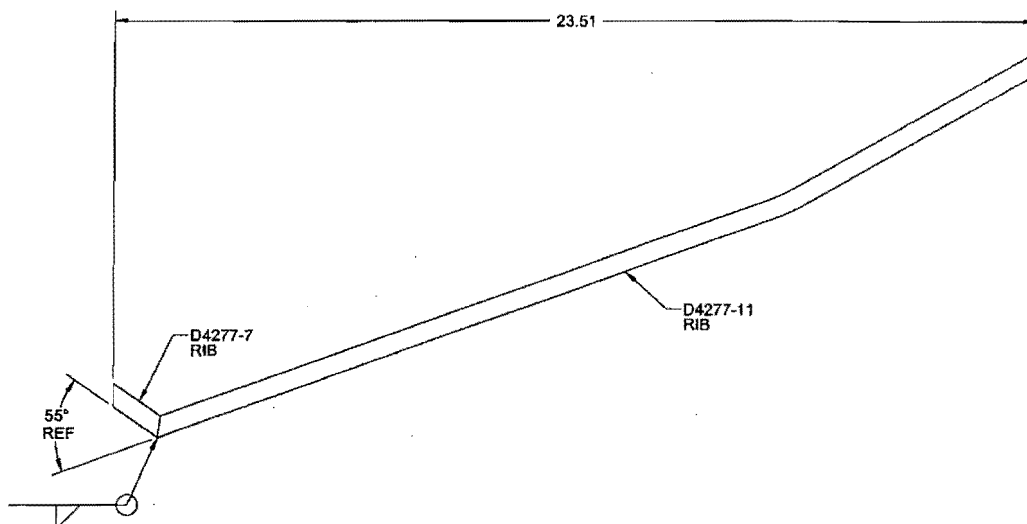
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

RELEASED
2011-01-18

DESIGN	JRH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
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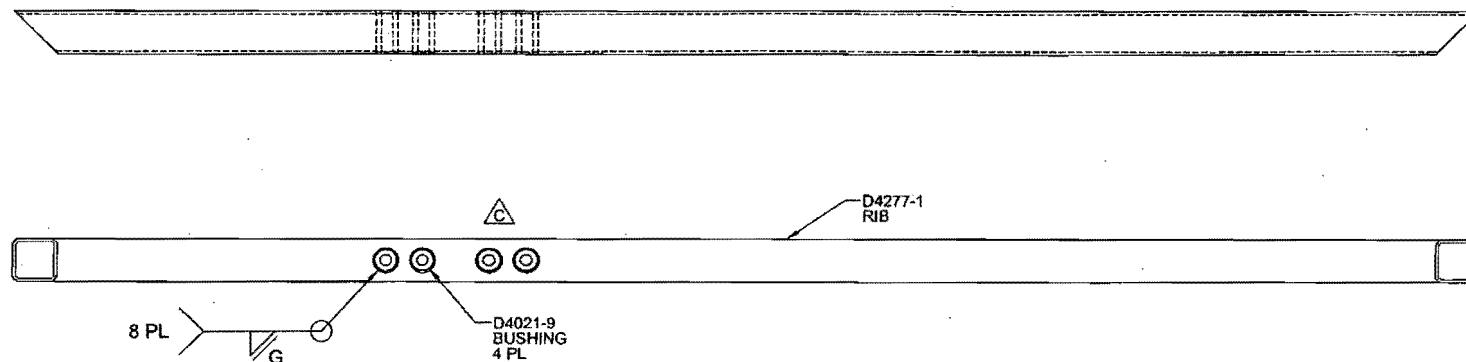
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NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
	4	D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

RELEASED
2011-01-10
MD

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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